

5259260



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5785-1

Job Sheet 207417

NO 20.02.28



POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Part No: D5785-1

Job Qty: 20 pcs

Part Name: Lid Bracket



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Status: New

Placed by \_\_\_\_\_ Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG 5785 REV.A IPP REV:A NEW ISSUE 20.14.01 JV VERF:DD

Ship Via:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	3/6/20	3/6/20	0.17	1.26	Waterjet - Flow		20/02/28
110	QC 2	20 pcs	3/6/20	3/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/02/28
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

PRIORITY



				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120	QC 8	20 pcs	3/6/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Packaging 3-1 - Stock - B4B	20 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B

DATE  
40  
FEB 28 2020  
8-89

MBL

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	20 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	21 FEB 28 2020
				QC 21 - SA - 70	70
				QC 21 - SA - 53	

Part Op 100 - Cut D5785-1 as per dwg Prog Rev: A Dwg Rev: A Deburr as required

Descriptions: 110 - QC2- inspect parts off machine FAI/FAIB  
 120 - (QC8- Inspect parts - second check)  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
 140 - QC21- Final Inspection - Work Order Release

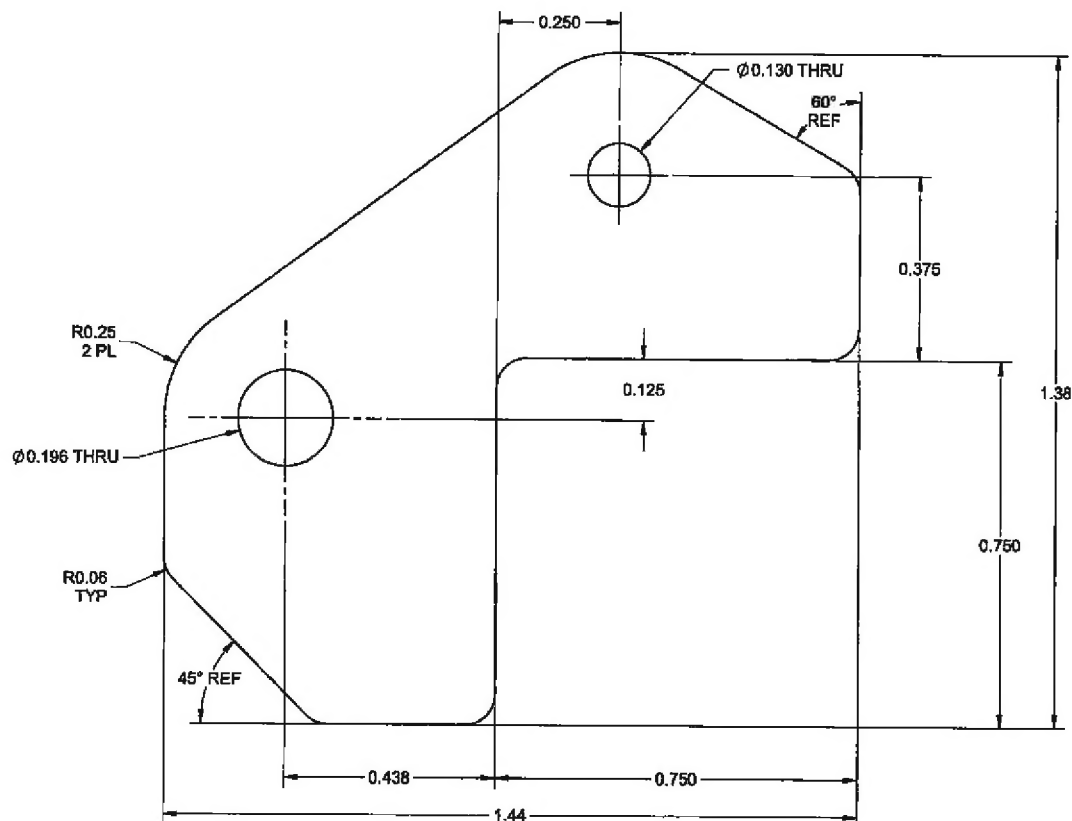
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.2880 sf (.0144 ea)	100-Waterjet - Flow - 1	<del>3243764</del> 3243764

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	0	585	0

Part Specifications	
Specifications could not be found.	

Plex 2/26/20 10:04 AM Dart.lajeunesse.marie





**D5785-1 BRACKET**  
(DERIVED FROM AERO DESIGN P/N 36273-01)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 207417

MW  
200226

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED, #18 GA (0.050 THICK)  
PER MIL-S-6069 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs
- 8) ALL NON-DIMENSIONED FEATURES WITHIN 0.030 OF "D5785-1-REVA.DXF"

RELEASED

2020 FEB 18 NO

APPROVED

DESIGN ZF  
DRAWN ZF  
CHECKED KPT  
MFG. APPR. DD  
APPROVED NO  
DE APPR. CP  
DATE 20.01.09

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D5785**

TITLE

**HANDLE BRACKET**

REV. A

SHEET 2 OF 3

SCALE

NTS

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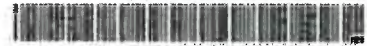




Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **POHB045418**



**Supplier:** ACI301-VC  
Acler Ouellette Inc.  
935 Boul. Du Havre  
Valleyfield  
QC  
J6S 6L1 Canada  
Phone: 800 667 4248  
Fax: 450 377 5896

**Attention:** Langevin, Melania

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**PO No:** POHB045418

**PO Date:** 12/17/19

**Due Date:** 12/20/19

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Phone:

DEC 17 2019

**Via:** Ground

**Pynt Terms:** Net 60

**Freight Terms:**

**Special Comments:** QUOTE NO. SOU0236838

## **Items**

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M5063T5C.75X.75W.125			6063-T5 Channel 0.750" x 0.750" x 0.125" wall receive fit	Firmed -		12/20/19	21 ft	21 ft	21 ft	\$1.038/ft	\$21.13
2		M5063T5A0.750W.083			6063-T5 Angle .750 X.750 X.083 WALL receive fit	Firmed -		12/20/19	21 ft	21 ft	21 ft	\$0.3757142/ft	\$7.89
3		M304S18GA			304/316 050 Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5358 OR AMS 5613 (304) OR AMS 5624 (316) OR ASTM A240 OR ASME SA240	Firmed -		12/20/19	320 sf	320 sf	320 sf	\$5.8679375/sf	\$1,813.74

**ACIER OUELLETTE INC.**

937, Boul. du Havre  
Sahaberry de Valleyfield (Quebec) J6S 5L1  
Tel: 450-377-4248 MH: 514-336-4248 Ext.: 800-667-4248  
Fax: 450-377-5696 MH: 514-336-4246 Ext.: 866-456-4242

**DELIVERY - CLIENT***CR 80*

C000184919

<b>Billed to</b>	<b>Shipped to</b>	<b>Customer N°</b>	CLIC001056
DART AEROSPACE LTD		<b>Date</b>	2019/12/17
1270, ABERDEEN ST.	1270, ABERDEEN ST.	<b>Delivery date</b>	<b>2019/12/19</b>
HAWKESBURY, Ontario, K6A 1K7	HAWKESBURY, Ontario, K6A 1K7	<b>Your order N°</b>	POHB045418
		<b>Processed by</b>	Josianne Bourdon
		<b>Salesman</b>	JOSIANNE BOURDON
<b>Instruction</b> FM	<b>Att :</b> CHANTAL	<b>Carrier</b>	OUELLETTE VALLEYFIELD
	<b>Delivery Route</b> 5 + <i>WRAP</i> <i>9'V8</i>	<b>Credit Terme</b>	Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CHANNEL ALU 3/4 X 3/4 X 1/8 6063-T5 * CHAL-343418 1981 1 X 21' POHB045418 LINE 1 CAST; 19193172	6.17	21.00	PI 3CLB		21'						
2 ANGLE ALU 3/4 X 3/4 X 1/16 C 6063-T5 * AAL-3434116 1361 1 X 21' POHB045418 LINE 2 CAST-41324	2.25	21.00	PI 1CLB		21'						
3 SHEET SS 18G SS304-2B DART FESSD-18G3042B-V 12468 10 X 4' X 8' POHB045418 LINE 3 HEAT YU187124 PACKAGING	672.00	370.00	PI2 3CLB		10X						
4 SHEET SS 11G SS304-2B (4 X 8) FESS-11G483042B 3402 2 X 4' X 8' POHB045418 LINE 1 HEAT D73E	336.00	64.00	PI2 3CLB		2X						
5 SHEET SS 14G SS304-2B (4 X 8) FESS-14G483042B 3412 2 X 4' X 8' POHB045418 LINE 5 HEAT L25HC10	209.98	64.00	PI2 3CLB		2X						

LIVE 3

# MATERIAL RECEIPT INSPECTION FORM

POM 13045413

MATERIAL M 13045413

PO / BATCH NO: POM 13045413

DATE DEC 24 2019

5243404

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: .050

QUANTITY RECEIVED: 32058

THICKNESS RECEIVED: .050

QUANTITY INSPECTED: 32058

SHEET SIZE ORDERED: 4' x 8'

QUANTITY REJECTED: 458

SHEET SIZE RECEIVED: 4' x 8'

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	<u>CIRCLED STAINS ON SHEET (1)</u>
CORRECT FINISH	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORROSION	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT MATERIAL PER M-DRAWING	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	<u>ASTM A240</u>
CORRECT THICKNESS	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
PHOTO REQUIRED	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	<u>HIS 70187124</u>
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

*Testers located in the Quality Office*

QC IS INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY <u>82</u>	SIGNED OFF BY: _____
DATE: <u>DEC 24 2019</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



LINE 3

KIT YU187124

M304S186A

# **SPECIFICATION CONTROL DRAWING**

PURCHASE MATERIAL: AISI 304/316 SS SHEET  
(ANNEAL ED)

DAS  
82  
0-85

DEC 2 1 2019

SPECIFICATION: MIL-3-1078  
OR AMS 5213 (200)  
OR AMS 5228 (316)  
OR ASTM A240  
OR SAME SAE/AS

FINISH

FINISH	DART NUMBER IDENTIFIER
UNPOLISHED NO. 1	1P
UNPOLISHED NO. 20	2P
UNPOLISHED NO. 20	NONE
POLISHED NO. 3	1P
POLISHED NO. 3	2P
BUFFED NO. 6	3P
BUFFED NO. 7	7P
BUFFED NO. 8	8P

PART NUMBER: M304S186A

WHERE "TT" = GAUGE THICKNESS  
WHERE "FF" = FINISH IDENTIFIER

EG: 16 GAUGE SS SHEET TO FINISH = M304S186A  
EG: 16 GAUGE SS SHEET NO. 3 POLISHED = M304S186A3P

GAUGE THICKNESS REFERENCE:

GAUGE	NO.1 THICK (IN)	THICKNESS RANGE (IN)
20	0.01675	0.0175 - 0.018
18	0.01675	0.0185 - 0.019
16	0.016	0.017 - 0.018
14	0.01575	0.017 - 0.018
12	0.01575	0.017 - 0.018
10	0.01575	0.017 - 0.018
8	0.01575	0.017 - 0.018
6	0.01575	0.017 - 0.018
4	0.01575	0.017 - 0.018
2	0.01575	0.017 - 0.018
0	0.01575	0.017 - 0.018

RELEASED

2015 FEB 04

2015 FEB 04

DESIGN	DB	DART AEROSPACE LTD	REV D
DRAWN	4/8	MAGNETIC COATING CO.	SHEET 1 OF 1
CHECKED		M304S	SCALE
DATE APPRO		304/316 SS SHEET	DATE
DATE	15.01.06		

FESS-18G483042B

TRA 3686 52742

**MILL TEST CERTIFICATE**

Invoice No.: 9QCAEW602TB6

Steel Grade: AISI 304L

Date: 2018/07/29

Surface Finish: 2B

Page: P02/P04

Grade: STAINLESS STEEL COLD ROLLED SHEETS

Specification: ASTM A240/A480

Certificate No.: PTTV020604TB6

Product ID	Chemical Composition (%)											Mechanical Properties				
	C	Mn	P	S	Ni	Cr	N					Tensile Test			Hardness Test	
												Y.S. (ksi)	T.S. (ksi)	EL (%)	HRB	HV
75S43073B-23	0.018	0.360	0.037	0.004	8.01	18.09	0.038					297	647	50.0	82	162
75S43073B-24	0.018	0.360	0.037	0.004	8.01	18.09	0.038					297	647	50.0	82	162
75S43476-7	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
75S43476-8	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
75S43476-9	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
75S43476-A	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
75S43476-B	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
75S43476-1	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
75S43476-2	0.029	0.330	0.035	0.009	8.07	18.05	0.040					298	647	50.0	82	162
76S87832A-1	0.024	0.380	0.029	0.002	8.03	18.30	0.036					298	647	50.0	82	162
Product ID	Heat No.	SIZE					PCS	Remarks								
75S43073B-25	YU280024	16GA X 60" X 120"					21	REFERRING TO ASTM SPEC P01NUMBER: 18-P-265 LCNUMBER: DC H/0812260 OSL NUMBER: K100CTR/7829 CERTIFICATE NUMBER: MEDU7774102, MEDU6000003 Manager Of QA Dept.  K.C.W.								
75S43073B-24	YU280024	16GA X 60" X 120"					20									
75S43476-7	YU187124	18GA X 48" X 96"					49									
75S43476-8	YU187124	18GA X 48" X 96"					49									
75S43476-9	YU187124	18GA X 48" X 96"					49									
75S43476-A	YU187124	18GA X 48" X 96"					49									
75S43476-B	YU187124	18GA X 48" X 96"					54									
75S43476-1	YU187124	18GA X 48" X 120"					33									
75S43476-2	YU187124	18GA X 48" X 120"					33									
76S87832A-1	LZ256A09	18GA X 60" X 120"					50									

We hereby certify that the material described herein has been examined and tested with satisfactory results in accordance with the requirement of the above material specification.

Heat: YU 187124

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>		
Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
<b>Root Cause</b>  <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>	<b>FAULT CATEGORY</b>  <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:				